

Date: Tuesday, 15/07/2008 9:15:28 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	: 40492			Part Number	: D30403		
Estimate Number	: 11535			Drawing Number	: D3040 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 15/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:-		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 15/08/2008 Qty: 30 Um: Each		
Previous Run	: 35976						
Written By	:						
Checked & Approved By	: JLD 08.15.08						
Comment	: Est:B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev:A Now on Waterjet 07-03-07 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
Comment: Qty.: 0.3718 f(s)/Unit Total : 11.1542 f(s) 6061-T6 Bar .178" x 4.0"		Batch: 103386 HR 8-8-11
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3041 Dwg Rev: B HR 8-8-11 Prog Rev: B		(P15) →
		(33)
2-Deburr if necessary		11 8-8-12 JB
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		HR 8-8-11
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		(S08/08/12 x 200) counter
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PW		8/8/13 (30x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3040-3 PAR #: N/A Fault Category: Prod Fab. Ass 'Med' NCR: Yes No DQA: D Date: 08/08/14
 QA: N/C Closed: D Date: 08/08/14

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/12	# 2.2	2 parts have defects found During inspection. 1- has a cut /mark from crater jet mounty across the	<u>J</u> <u>08/08/12</u>	Scrap & destroy No replace.	<u>S</u> <u>08/08/12</u>	<u>J</u> <u>08/08/12</u>	<u>C</u> <u>08/08/12</u>	<u>C</u> <u>08/08/12</u>
		Part with pressure left on. PC machine malfunction. 2- has a deburring mark about 0.030 on the non welded	<u>J</u> <u>08/08/12</u>			<u>S</u> <u>08/08/12</u>	<u>J</u> <u>08/08/12</u>	<u>C</u> <u>08/08/12</u>
		Side- R.C. Human error	<u>J</u> <u>08/08/12</u>	<u>V</u>		<u>S</u> <u>08/08/12</u>	<u>J</u> <u>08/08/12</u>	<u>C</u> <u>08/08/12</u>

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:29 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 40492

Part Number: D30403

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



(30)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/08/14

Job Completion



U 08.08.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40492
Description: Mounting Lug	Part Number:	D3040-3
Inspection Dwg: D3040	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

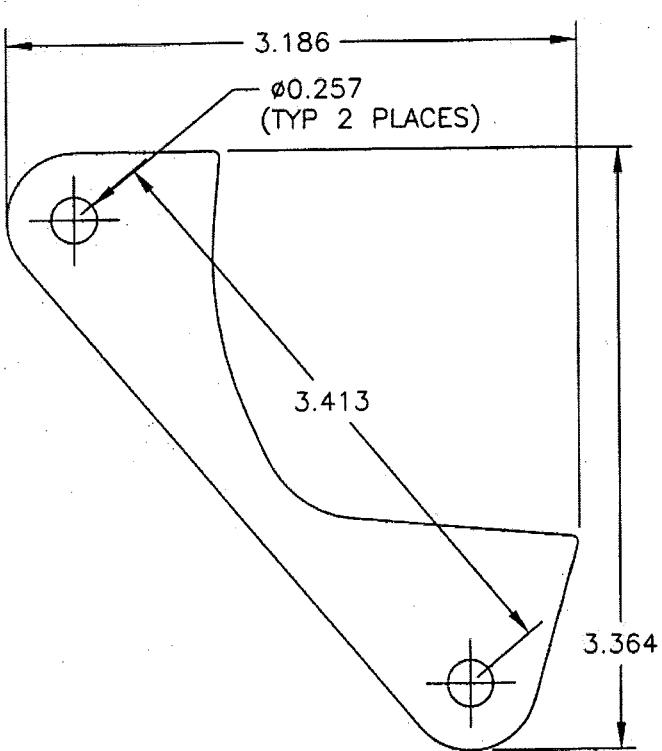
X First Article Prototype

Measured by:	<u>KB</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-8-11	Date:	08/08/12	Date:	N/A

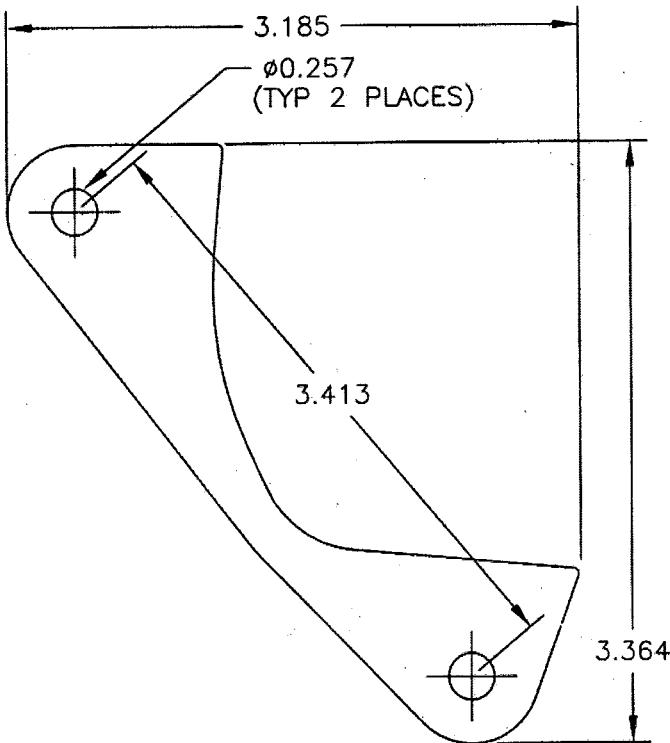
Rev	Date	Change	Revised by	Approved
A	07.04.20	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3040	REV. B SHEET 1 OF 1
DATE 01.09.04	TITLE MOUNTING LUG		SCALE 1:1
A	01.06.27	NEW ISSUE	
B	01.09.04	CHANGED PROFILE 5 DEGREES	

RELEASED
01.09.07

D3040-1



D3040-3

NOTES

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
(REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40492

Copyright © 2001 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.